

*Non Eurocopter*

**Work Order ID 56631**

March 3, 2010 8:44:27 AM



Page 1

Item ID: D350-591-312

Accept



Setup Start



Revision ID:

Item Name: Heli-Access-Step, Long RH

Stop



Start Date: 3/03/10 Start Qty: 4.00



Cust Item ID:

Required Date: 3/08/10 Req'd Qty: 4.00

Customer:

Reference:

Approvals: Process Plan: *W*

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3272

Rev B

100



DC

Document Control

DOCUMENT CONTROL

0.00

Memo

*SA 92+*

0.00

Photocopy bluefile and type labels as per PPP D350-591-312  
ATTN: CHG002 -NON EUROCOPTER

*8/10/23*

*HJL CL 10/03/22*

110



Large Fab

Large Fab

Large Fab

0.00

Memo

1-Bevel end for welding FWD ONLY

0.00

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod *M111311*  
*M110130*

3-Grind End Plate flush

*SL 10.03.09*

*4* *φ*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

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Page 2

Item ID: D350-591-312

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Item Name: Heli-Access-Step, Long RH

Start Date: 3/03/10 Start Qty: 4.00

Required Date: 3/08/10 Req'd Qty: 4.00

Reference:

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Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

④

D 10.03.09

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

S 10/03/09

④  
x4  
R7

φ

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

K 10.03.09

4

φ



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 3

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Required Date: 3/08/10 Req'd Qty: 4.00

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150



QC

Quality Control

QC3- Inspect Part Finish

0.00

*W*

*10/03/09*

*(X4)*

*φ*

Memo

0.00

180



Large Fab

Large Fab

Large Fab

0.00

Memo

0.00

1-Assemble Leg Assembly as per Dwg D3272.

2-Leave one rivet out until welding is complete.

3-Bevel Aft end for welding

4-Inspect for foreign object as per QSI 024

5-Weld Aft End Plate as per QSI 004 & Dwg D3272

A/R ☐ Aluminum Rod ☒ *mill 311*

6-Grind End Plate flush

7-Install last rivet as per Dwg.

*10-03-15*

*4*

*φ*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 4

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Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

① PD 10.03.15

200

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8.10.03.16



210

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

10/05/12



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Cust Item ID:

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

220

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Powder Coating

Memo

START TIME: 10:45am

OVEN TEMPERATURE: 320°F

FINISH TIME: 11:15am

0.00

=> MJ 10/03/17

X4RH

230

Wing Walk as per dwg QSI005 4.4 Batch

0.00



HandFinish

Hand Finishing

Memo

0.00

BR 10-3-17

HRH

240

QC3- Inspect Part Finish

0.00



QC

Quality Control

Memo

0.00

8 10/03/23

X4RH

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Start Date: 3/03/10 Start Qty: 4.00



Required Date: 3/08/10 Req'd Qty: 4.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

250



Packaging

Pick Kit

0.00

Memo

0.00

Packaging

10-3-20 SL (40)

260



QC

QC4- 100% Inspect kits for completeness

0.00

Memo

0.00

Quality Control

8 10/03/23



270



Packaging

Packaging

0.00

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD350-591-312

Location: 6 FG72

MEU

Plu/3/24 (4)



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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**Work Order ID 56631**

March 3, 2010 8:44:44 AM



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Item ID: D350-591-312

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Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step, Long RH

Start Date: 3/03/10 Start Qty: 4.00



Cust Item ID:

Required Date: 3/08/10 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

280

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/03/24

mf  
10-3-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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March 3, 2010 8:44:15 AM

Page 1

Work Order ID: 56631

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Comments:

IPP Rev:A 04.03.22 New issue KJ/RF  
 IPP Rev:B 07-06-09 Added D3572-1 JLM  
 IPP Rev:C 08-04-02 ECN1163 DD verified by:EC  
 IPP Rev:D 08-04-08 ECN1164 DD verified by:EC

Start Date: 3/03/10

Required Date: 3/08/10

Start Qty: 4.00

Required Qty: 4.00

D3065-041

Manufactured No

Each 47.0000 4.0000



Step Leg Assembly Hi

Warehouse  
Location

Main Warehouse

WA

47

53795

17

55450

30

Manufactured No

Each 16.0000 8.0000

D3066-1



Spacer

Warehouse  
Location

Main Warehouse

ST

16

51545

11

53783

5

Manufactured No

Each 32.0000 8.0000

D3219-1



Plate

Warehouse  
Location

Main Warehouse

ST

32

53789

32

Manufactured No

Each 0.0000 4.0000

DSI 9410-011



Step Modification

0403001

phg

\*

B56636 10-3-22

40

10-03-11

4

10-03-11

7

1

10-03-09

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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March 3, 2010 8:44:16 AM

Page 2

Work Order ID: 56631

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Comments:

IPP Rev:A ☐ 04.03.22 ☐ New issue ☐ KJ/RF ☐  
 IPP Rev:B 07-06-09 Added D3572-1 JLM  
 IPP Rev:C 08-04-02 ECN1163 DD verified by:EC  
 IPP Rev:D 08-04-08 ECN1164 DD verified by:eC

Start Date: 3/03/10

Required Date: 3/08/10

Start Qty: 4.00

Required Qty: 4.00

D3067-1



End Plate

Manufactured

No

110

Each

27.0000

4.0000



*10-03-09*

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

27

*53784*

27

Manufactured

No

110

Each

0.0000

4.0000



*4*

*10-03-15 356633*

D3272-1



Step

MS21042L5



Nut

Purchased

No

110

Each

391.0000

8.0000



*10-03-15 356633*  
*10-3-22sl (4)*

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

390

110382

10

111636

1

112314

16

113523

163

*113537*

200

Main Warehouse

ST139

1

112314

1

*8*

March 3, 2010 8:44:16 AM

Shop Packet Print

Page 2



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 3

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Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Comments: IPP Rev:A 04.03.22 New issue KJ/RF

IPP Rev:B 07-06-09 Added D3572-1 JLM

IPP Rev:C 08-04-02 ECN1163 DD verified by:EC

IPP Rev:D 08-04-08 ECN1164 DD verified by:cC

Start Date: 3/03/10

Required Date: 3/08/10

Start Qty: 4.00

Required Qty: 4.00

MS20600-AD4W4

Purchased

No

180

Each

995.0000

64.0000



Rivets

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST

995

110731

215

111359

46

111477

74

112314

136

112385

24

113368

500

10-03-15

AN3-35A

Purchased

No

260

Each

195.0000

8.0000



Bolt

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST

195

106993

12

110467

1

112314

182

10-3-27 40

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Shop Packet Print

Page 3

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Page 4

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Parent Item Name: Heli-Access-Step, Long RH

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 IPP Rev:B 07-06-09 Added D3572-1 JLM  
 IPP Rev:C 08-04-02 ECN1163 DD verified by:EC  
 IPP Rev:D 08-04-08 ECN1164 DD verified by:eC

Start Date: 3/03/10

Required Date: 3/08/10

Start Qty: 4.00

Required Qty: 4.00

AN4-13A Purchased No 260 Each 211.0000 32.0000



Bolt

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	211	
113359	11	
113749	200	
17406	0	
51764	0	

8x 24x  
 M109285 M113749  
 10-3-22 SP

AN5-36A Purchased No 260 Each 115.0000 8.0000



Bolt

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	115	
109545	11	
110467	7	
110731	4	
112243	20	
112314	23	
112385	50	

10-3-22 SP

QSI 017

AN5149100363 QSI 017

AN960JD10 Purchased No 260 Each 0.0000 16.0000



Washer

M113288 10-3-22 SP 4x

March 3, 2010 8:44:17 AM

Shop Packet Print

Page 4

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 IPP Rev:C 08-04-02 ECN1163 DD verified by:EC  
 IPP Rev:D 08-04-08 ECN1164 DD verified by:cC

Start Date: 3/03/10

Required Date: 3/08/10

Start Qty: 4.00

Required Qty: 4.00

AN960JD416		Purchased	No	260	Each	0.0000	64.0000
Washer							
AN960JD516		Purchased	No	260	Each	0.0000	16.0000
Washer							
D2230-3		Manufactured	No	260	Each	178.0000	16.0000
Lug							

M113706

10-3-22 SP

M113524

10-3-22 SP

10-3-22 SP

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	7	
50306	5	
51568	2	
Main Warehouse		
ST176	150	
55310	150	
Main Warehouse		
ST476	21	
55310	21	

10

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Shop Packet Print

Page 5



W/O:		WORK ORDER CHANGES					
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 IPP Rev:B 07-06-09 Added D3572-1 JLM  
 IPP Rev:C 08-04-02 ECN1163 DD verified by:EC  
 IPP Rev:D 08-04-08 ECN1164 DD verified by:cC

Start Date: 3/03/10

Required Date: 3/08/10

Start Qty: 4.00

Required Qty: 4.00

D2618 Manufactured No 260 Each 61.0000 8.0000



Bushing

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

ST39

61

50989

61

Manufactured No

260

f

249.0321

2.4000



Abraison Strip

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

ST403

249.0320842

50593

138.592084

52563

110.44

Manufactured No

260

Each

27.0000

4.0000



End Plate

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

ST

27

53784

27

10-3-22-21

10-3-22-21

10-3-22-21

10-03-15

4

March 3, 2010 8:44:18 AM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Page 7

March 3, 2010 8:44:19 AM

Work Order ID: 56631



Parent Item: D350-591-312



Parent Item Name: Heli-Access-Step, Long RH

Start Date: 3/03/10

Required Date: 3/08/10

Comments:

IPP Rev:A 04.03.22 New issue KJ/RF

Start Qty: 4.00

Required Qty: 4.00

IPP Rev:B 07-06-09 Added D3572-1 JLM

IPP Rev:C 08-04-02 ECN1163 DD verified by:EC

IPP Rev:D 08-04-08 ECN1164 DD verified by:eC

D3235-1 Manufactured No 260 Each 107.0000 8.0000



Mounting Lug

10-3-22 sl

Warehouse Loc Qty Loc Code

Location

Main Warehouse

471 60

55315 60

Main Warehouse

ST 47

45398 4

54756 43

4

D3278-041 Manufactured No 260 Each 63.0000 4.0000



Support Assembly

10-3-22 sl (K)

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 23

53227 23

Main Warehouse

ST471 40

55318 40

4

March 3, 2010 8:44:19 AM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

March 3, 2010 8:44:20 AM

Page 8

Work Order ID: 56631



Parent Item: D350-591-312



Parent Item Name: Heli-Access-Step, Long RH

Start Date: 3/03/10

Required Date: 3/08/10

Comments:

IPP Rev:A ☐ 04.03.22 ☐ New issue ☐ KJ/RF ☐

Start Qty: 4.00

Required Qty: 4.00

IPP Rev:B 07-06-09 Added D3572-1 JLM

IPP Rev:C 08-04-02 ECN1163 DD verified by:EC

IPP Rev:D 08-04-08 ECN1164 DD verified by:cC

MS21042L3

Purchased

No

260

Each

2,470.000 8.0000



Nut



10-3-229

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST

2464

110844

35

111274

27

111668

52

112314

285

112385

347

113523

18

113537

700

113644

1000

Main Warehouse

ST139

6

111668

6

March 3, 2010 8:44:20 AM

Shop Packet Print

Page 8



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

March 3, 2010 8:44:26 AM

Page 9

Work Order ID: 56631

Parent Item: D350-591-312

Parent Item Name: Heli-Access-Step, Long RH

Comments:

IPP Rev:A 04.03.22 New issue KJ/RF  
 IPP Rev:B 07-06-09 Added D3572-1 JLM  
 IPP Rev:C 08-04-02 ECN1163 DD verified by:EC  
 IPP Rev:D 08-04-08 ECN1164 DD verified by:eC

Start Date: 3/03/10

Required Date: 3/08/10

Start Qty: 4.00

Required Qty: 4.00

MS21042L4

Purchased

No

260

Each

1,821.000 32.0000

Nut

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1821

102552

6

104248

6

110507

184

111827

631

113422

994

15924

0

10.3.22.21 (4x)

32

March 3, 2010 8:44:26 AM

Shop Packet Print

Page 9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**DART**

DESIGN <i>qp</i>	DRAWN BY <i>B</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

**RELEASED***07.06.04 - ff*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

**GENERAL NOTES:**

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

*W.D. 06/03***Copyright © 2004 by DART AEROSPACE LTD**

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

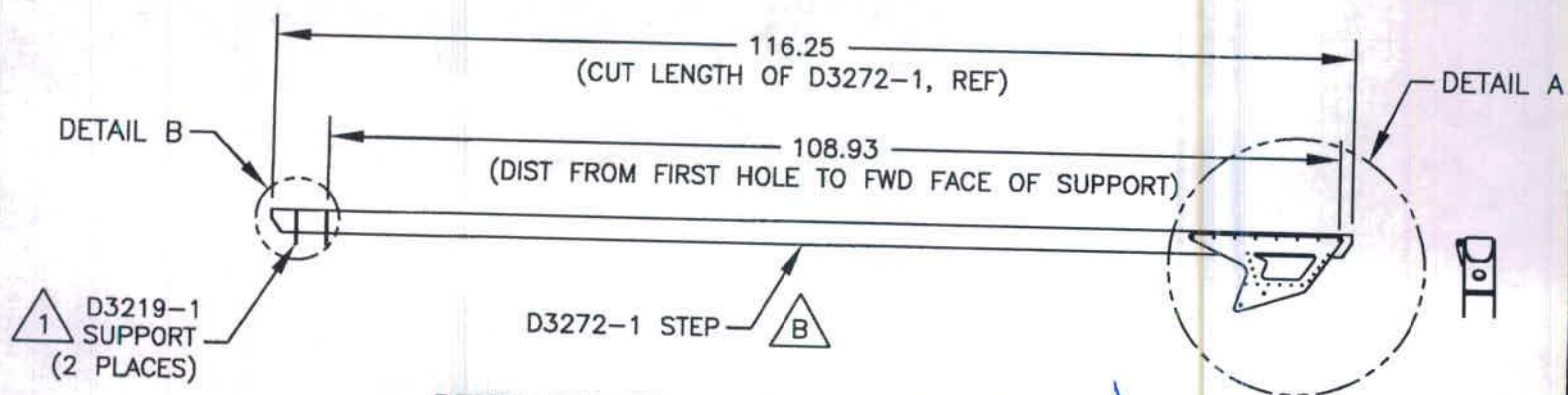
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

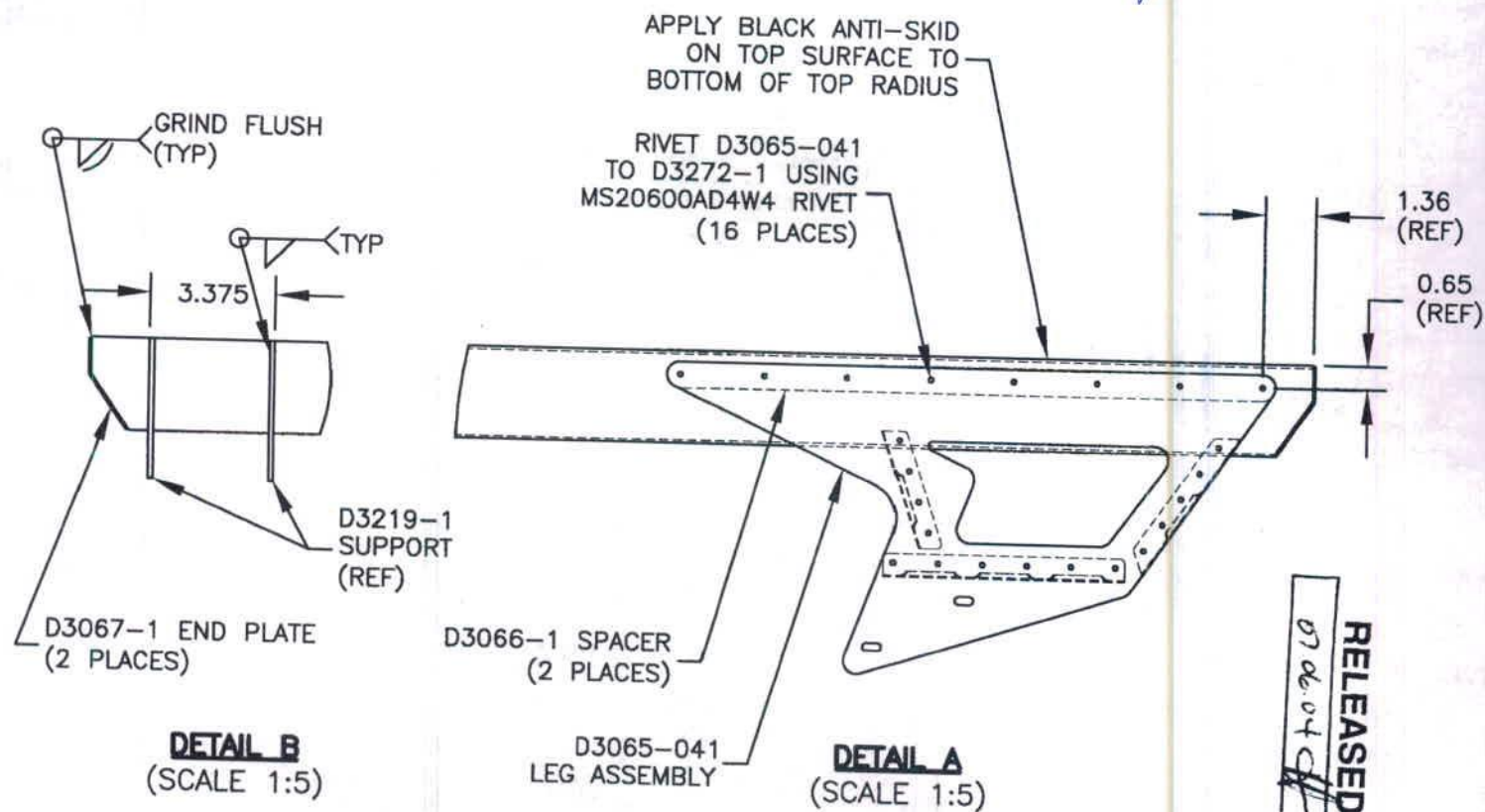


# DART

DESIGN	AP	DRAWN BY	JB	DART AEROSPACE LTD
CHECKED	CE	APPROVED	JB	HAWKESBURY, ONTARIO, CANADA
DATE	07.05.18	DRAWING NO.	D3272	REV. B
		TITLE	STEP ASSEMBLY, HI LONG	SHEET 2 OF 3
		SCALE	1:20	



**D3272-041 STEP ASSEMBLY (LH. SHOWN)**  
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)





W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

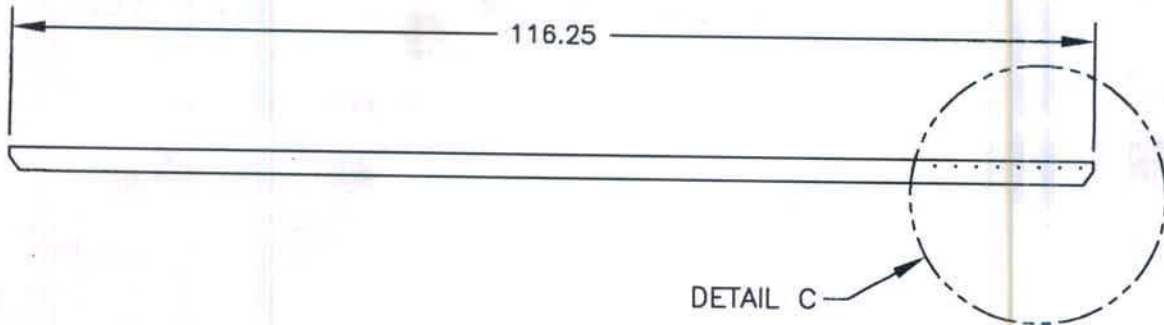
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

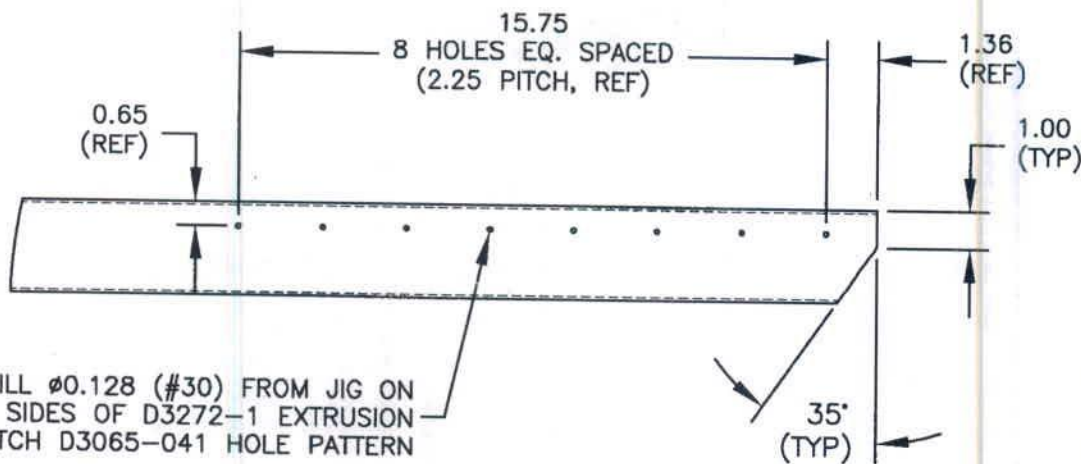
**DART**

DESIGN	99	DRAWN BY	JR	DART AEROSPACE LTD
CHECKED	CE	APPROVED	JR	HAWKESBURY, ONTARIO, CANADA
DATE	07.05.18	DRAWING NO.	D3272	REV. B
		TITLE	STEP ASSEMBLY, HI LONG	SHEET 3 OF 3
		SCALE	1:20	



**B D3272-1 STEP**  
(MAKE FROM D2622-120 STEP EXTRUSION)

*who 56031*



DRILL  $\phi 0.128$  (#30) FROM JIG ON BOTH SIDES OF D3272-1 EXTRUSION TO MATCH D3065-041 HOLE PATTERN

**DETAIL C**  
(SCALE 1:5)

**RELEASED**

07.06.04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries